

Work Order ID 102254 -

\*102254\*

Page 1

Item ID: D3537-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearpad

Start Date: 6/14/13 Start Qty: 50.00

\*50\*

35

Cust Item ID:

Required Date: 6/14/13 Req'd Qty: 50.00

\*50\*

Customer:

Reference:

Approvals: Process Plan: *ML*

Date: 13-05-28

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537Dwg Rev:    Prog Rev:    2-Deburr  
if necessary

SB  
2  
5

EL 13-6-11

304.063

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

SB

EL 13-6-11

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

SB

13-6-12

09  
15



Work Order ID 102254

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Page 2

May-27-13 12:42:17 PM

Item ID: D3537-1

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearpad

Start Date: 6/14/13 Start Qty: 50.00

\*50\*

Cust Item ID:

Required Date: 6/14/13 Req'd Qty: 50.00

\*50\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Qty Reject Qty Reject Number Insp.  
Stamp

130

\*130\*

Brake NC

Brake NC

NC BRAKE

Memo

0.00

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.2-  
Identify as D3537-1

56x

13/06/12

140

\*140\*

Large Fab

Large Fab

Large Fab

Memo

0.00

Qty Description Batch A/R 2059B Harcoat  
m124397 1-Weld as per Dwg D3537 using Jig DT 82102-Remove any  
weld that penetrated through Wearpad if necessary

35

13-06-25

150

\*150\*

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

3626

35





Work Order ID 102254

\*102254\*

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May-27-13 12:42:17 PM

Item ID: D3537-1

Accept

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Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearpad

Start Date: 6/14/13 Start Qty: 50.00

\*50\*

Cust Item ID:

Required Date: 6/14/13 Req'd Qty: 50.00

\*50\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

\*160\*

QC

Memo

0.00

Quality Control

0.00  
DAS  
27  
0.00  
BG 26

35

170

Grey Sandtex(Ref:4.3 5.6) per QSI005 4.3

0.00

\*170\*

Powdercoat

Memo

0.00

Powder Coating

START TIME:

9:15

OVER TEMPERATURE:

3:00 FINISH TIME:

9:45

35 & 14 BG 28

180

QC3- Inspect Part Finish

0.00

\*180\*

QC

Memo

0.00

Quality Control

0.00  
DAS  
27  
0.00  
136 28

35



# Work Order ID 102254

\*102254\*

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May-27-13 12:42:17 PM

Item ID: D3537-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearpad

Start Date: 6/14/13 Start Qty: 50.00

\*50\*

Cust Item ID:

Required Date: 6/14/13 Req'd Qty: 50.00

\*50\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

190

Identify as per dwg & Stock Location: FP-001

0.00

\*190\*

Packaging

Memo

0.00

Packaging

x35 & JEL 13/07/02

200

QC21- Final Inspection - Work Order Release

0.00

\*200\*

QC

Memo

0.00

Quality Control

13/7/2 J

Mr. 13-7-02







# Picklist Print

May-27-13 12:42:17 PM

Work Order ID: 102254  
Parent Item: D3537-1  
Parent Item Name: Wearpad

Start Date: 6/14/13  
Start Qty: 50.00

Required Date: 6/14/13  
Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	446.0842	0.106	5.578945			

EL  
13-6-11

Location	Loc Qty	Loc Code
MAT020	446.0841688	
122245	0.1713688	
123136	140.8	
124428	23.61	
124572	25.5028	
125599	256	

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
6'



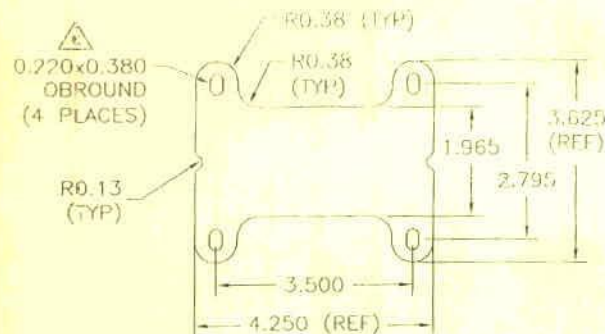




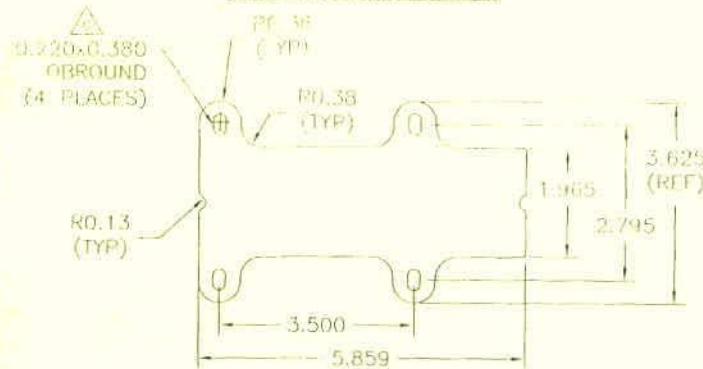




# D3537-1F FLAT PATTERN



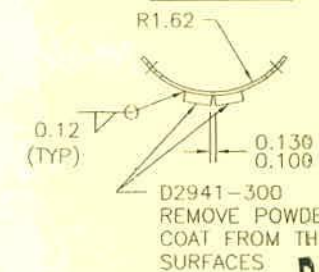
# D3537-3F FLAT PATTERN



# SECTION A-A



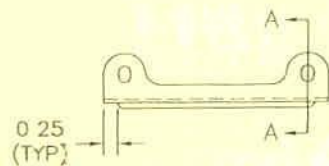
# SECTION B-B



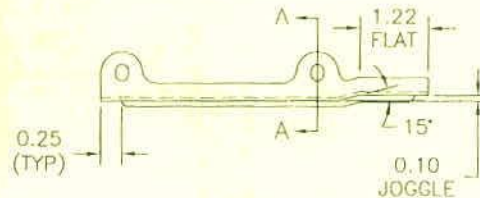
UNDER REVIEW

RELEASED  
07-05-03 PM  
per ECN 962

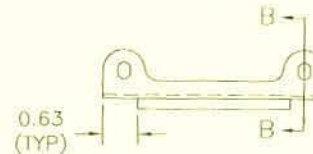
# D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



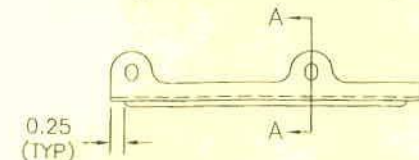
# D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



# D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



# D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



# D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	07.04.13	DRAWING NO. D3537
		TITLE WEARPAD
		REV. C SHEET 1 OF 1 SCALE 1:2

1305 28

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